

Work Order ID 48517

June 26, 2009 12:46:00 PM



Page 1

Item ID: D3592-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Plate

Start Date: 15/07/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3592	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3592 *****ENSURE GRAIN IS AT 45 DEG AS PER DEO D3592-b-1***** Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

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Date:

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Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Form as per Dwg D3592 using DT8949

→ Debaraz

8B 09/06/30
→ 09/07/01 m.k

(63)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

- 8 09/07/01 (63) counts

150

0.00



Identify as per dwg & Stock Location:

FAT

Packaging

Memo

0.00

Packaging

9/7/11

(63) SC

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Start Date: 15/07/2009 Start Qty: 60.00



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Required Date: 03/08/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

W 09.07.07

Picklist Print

June 26, 2009 12:46:00 PM

Work Order ID: 48517

Parent Item: D3592-1RevB

Parent Item Name: Plate

Comments:





Start Date: 15/07/2009

Required Date: 03/08/2009

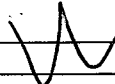
Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M6061T6S.125  6061-T6 .125 Sheet		Purchased	No			100	sf	0.0000	8.7789 			

Date: Friday, 12/06/2009 7:08:10 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	48517		
Estimate Number :	12811		
P.O. Number :		Part Number :	D35921
This Issue :	12/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3592 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	47015	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :		Due Date :	19/06/2009
Comment :	Est Rev:A New Issue 07-03.26 ec	Qty:	60
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6S125	6061-T6 .125 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.1460 sf(s)/Unit Total : 8.7570 sf(s)

6061-T6 .125 Sheet

Batch: 111642 B 9-6-19

Grain must be Along 4.63**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3592

*****ENSURE GRAIN IS AT 45 DEG AS PER DEO D3592-b-1*****

Dwg Rev: 3

Prog Rev: B

B 9-6-19

2-Deburr if necessary B 9-6-19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 9-6-19

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

center
 507/06/22
 63

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

M. 09/06/30
 SB 09/06/30

63

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 7:08:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 48517

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

48517

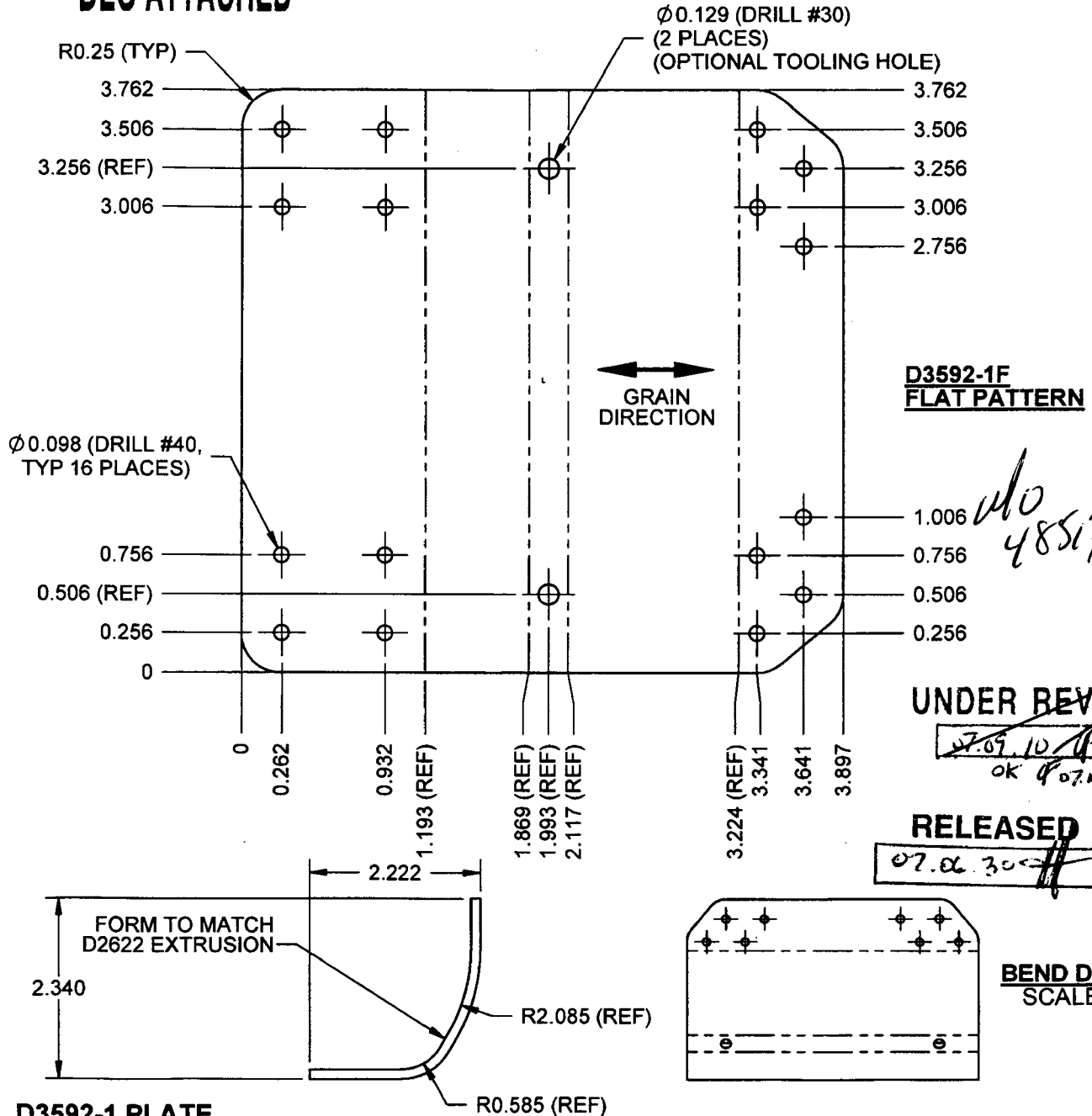
<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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Measured by: <i>IB</i>		Audited by: <i>S</i>		Prototype Approval: N/A	
Date: <i>9-6-9</i>		Date: <i>07/06/22</i>		Date: N/A	

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD <i>JA</i>	<i>IB</i>

DART

DESIGN <i>qp</i>	DRAWN BY <i>DL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

DEO ATTACHED**D3592-1 PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

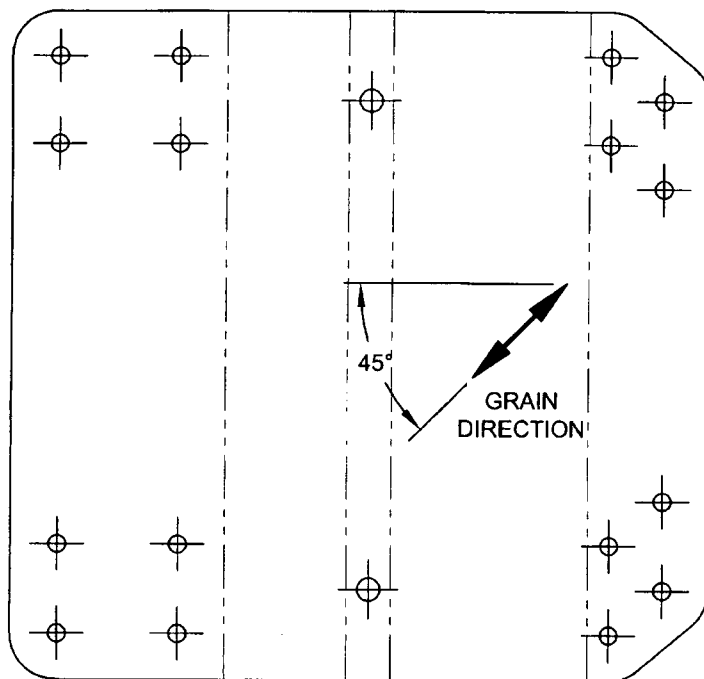
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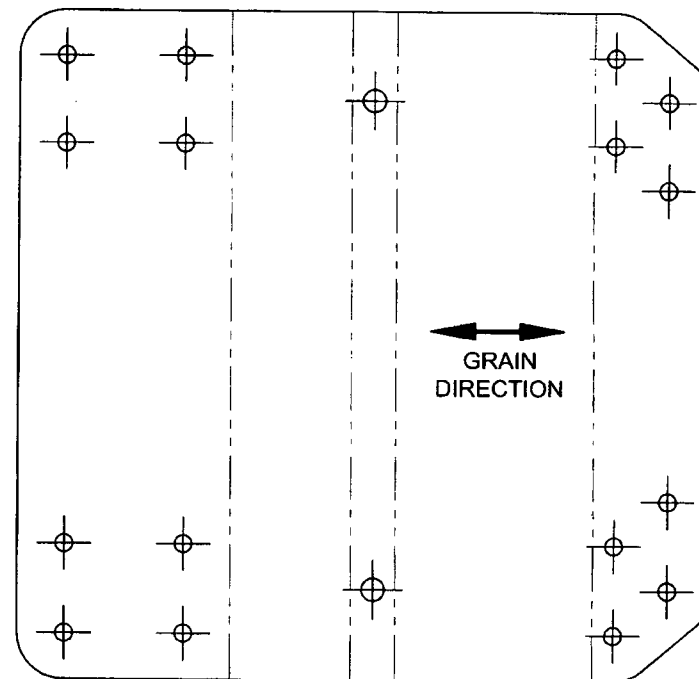
DRAWING NO. D3592	TITLE PLATE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3592-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.09.11	DATE 08.09.11	DATE 08/09/11	DATE 08/09/11		DATE 08/09/11		

MODIFY GRAIN DIRECTION AS SHOWN BELOW TO PREVENT CRACKING WHEN WELDING AT ASSEMBLY (SEE CAR 08-026).

IS:



WAS:



ALL OTHER INFORMATION REMAINS UNCHANGED

RELEASED
08.09.17/18